









Work Order ID 64299

Wednesday, December 01, 2010 2:49:45 PM


Page 1

Item ID: D2432 Accept  Setup Start 
 Revision ID: Stop 
 Item Name: 206 (24") Bearpaw
 Start Date: 12/1/2010 Start Qty: 12.00  Cust Item ID:
 Required Date: 12/10/2010 Req'd Qty: 12.00  Customer:
 Reference:

Approvals: Process Plan:  Date: 10-12-1 Tooling: Date: Run Start 
 QC: Date: SPC (Y/N): Date: Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2432	Rev F3

120	FLOW WATER JET	0.00							
	Waterjet								
	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								


10-12-21

12

130	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr								

10-12-21

11/01/04

140	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Memo	0.00							
Quality Control									

11/01/04

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date:	12/10/2010	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							

Quality Control

151	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging									

190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/01/06 (12)

OK *11/01/06*
MF
11-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, December 01, 2010 2:49:49 PM

Page 1

Work Order ID: 64299

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw



Start Date: 12/1/2010

Required Date: 12/10/2010

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

220.2114

3.7

44.4



2310-12-21

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT

220.2114

114624

5.9054

115325

15.506

115955

38.8

116281

160

116281

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 64222
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010					
B	5.500	+/-0.030					
C	0.200	+/-0.030					
D	0.25 x 45°	+/-0.030					
E	R0.250	+/-0.030					
F	0.250	+/-0.010					
G	0.625	+/-0.030					
H	0.375	+/-0.010					
I	0.950	+0.030/0.010					
J	19.000	+/-0.030					
K	3.14	+/-0.030					
L	3.28	+/-0.030					
M	Ø0.260	+0.005/-0.000					
N	Ø0.93	+/-0.030					
O	0.30	+0.030/-0.000					
P	23.750	+/-0.030					
Q	7.375	+/-0.030					
R	4.250	+/-0.010					
S	2.000	+/-0.030					
T	9.000	+/-0.010					
U	9.000	+/-0.010					
V	0.375	+/-0.010					

Measured by: JL
Date: 11/01/04

Audited by: B.A
Date: 11/01/05

Prototype Approval: N/A
Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015 KJ/RF	+

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITH

WORK

NO. 144294



14-0-12-1

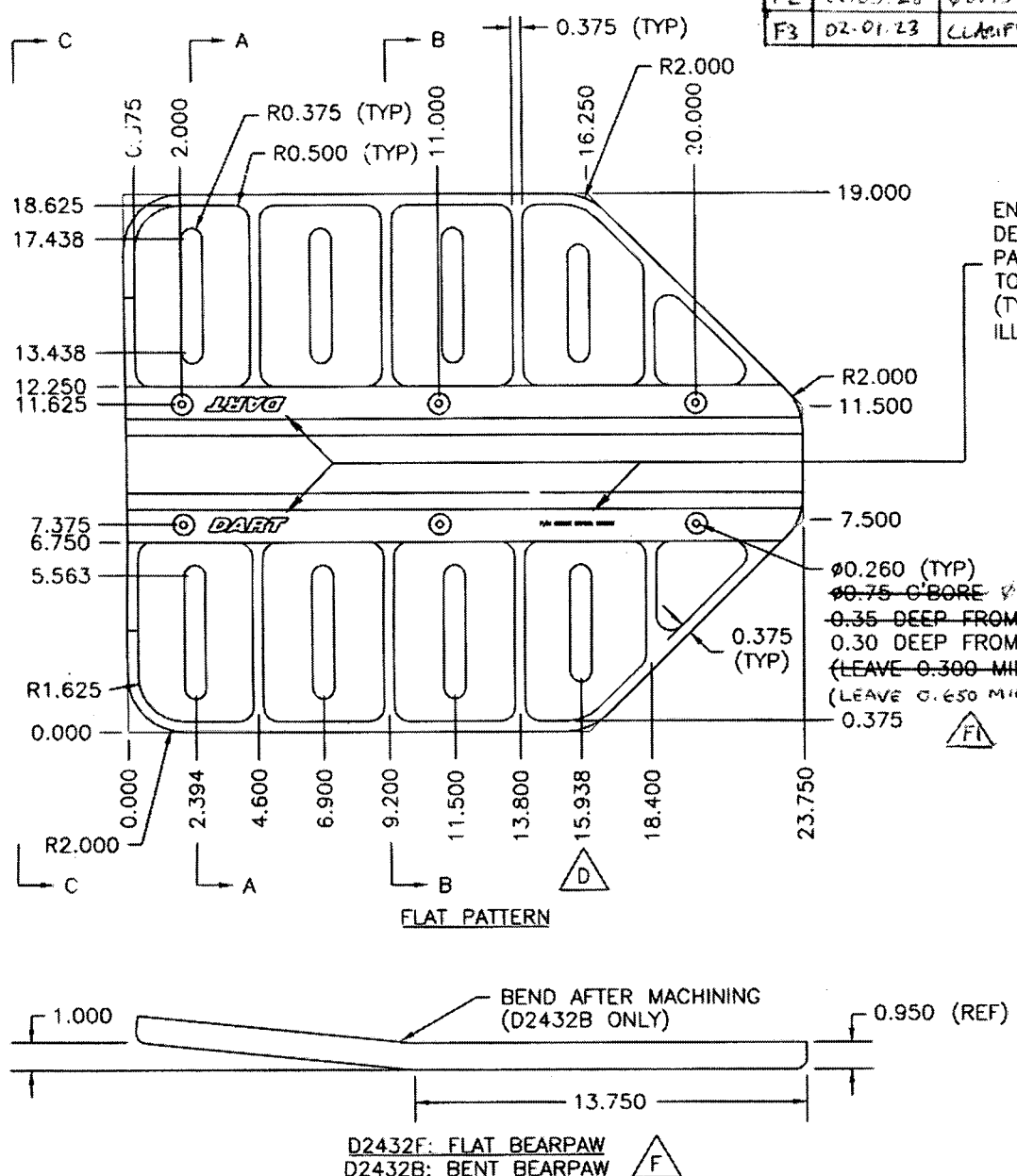
RELEASED
93.06.12 KE

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	KE	
CHECKED	APPROVED	DRAWING NO.
MB	KE	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE
		1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

EFFECTIVE	DEOS
9143	



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
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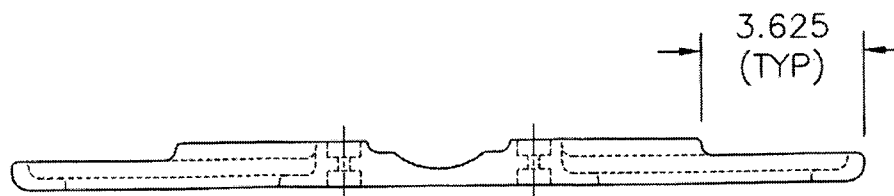
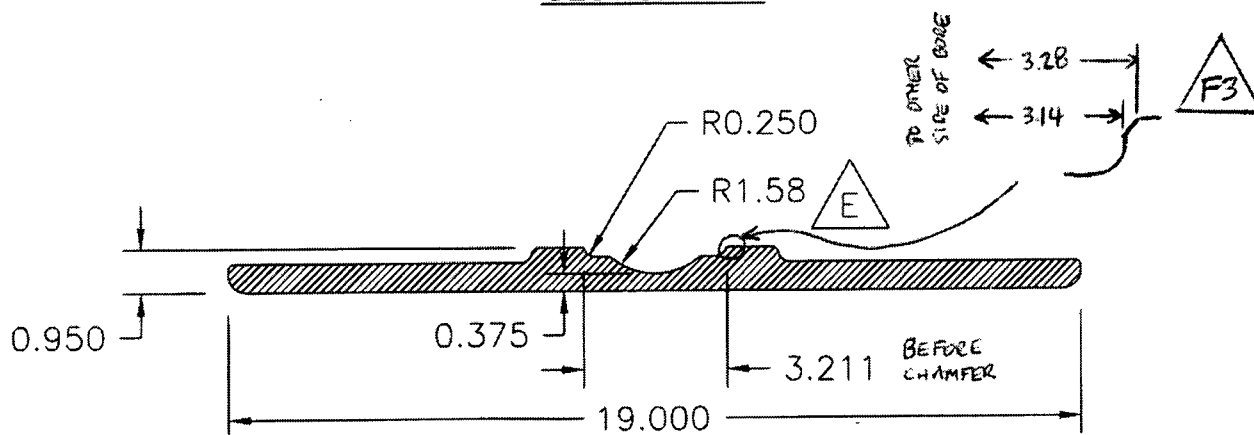
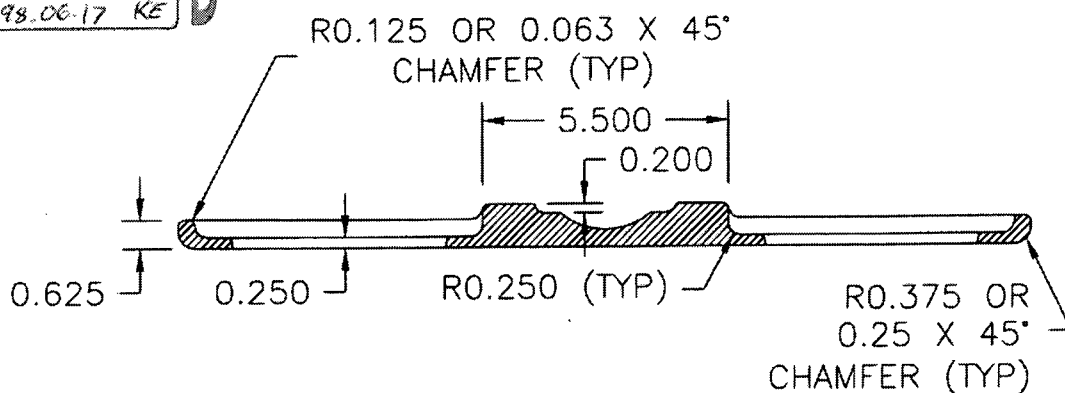
NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ME	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

u/o 64229



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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

DART AEROSPACE LTD		Work Order: 64701
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063x45°	✓		URN 31-3	
B	5.500	+/-0.030	5.505	✓		"	
C	0.200	+/-0.030	0.186	✓		"	
D	0.25 x 45°	+/-0.030	0.25x45°	✓		"	
E	R0.250	+/-0.030	0.250	✓		R-G	
F	0.250	+/-0.010	0.252	✓		"	
G	0.625	+/-0.030	0.620	✓		"	
H	0.375	+/-0.010	0.377	✓		"	
I	0.950	+0.030/0.010	0.950	✓		"	
J	19.000	+/-0.030	19.00	✓		m-tape	
K	3.14	+/-0.030	3.150	✓		"	
L	3.28	+/-0.030	3.290	✓		"	
M	Ø0.260	+0.005/-0.000	0.260	✓		"	
N	Ø0.93	+/-0.030	0.925	✓		"	
O	0.30	+0.030/-0.000	0.318	✓		"	
P	23.750	+/-0.030	23.750	✓		m-tape	
Q	7.375	+/-0.030	7.375	✓		URN CNC-02	
R	4.250	+/-0.010	4.250	✓		"	
S	2.000	+/-0.030	1.998	✓		"	
T	9.000	+/-0.010	9.000	✓		"	
U	9.000	+/-0.010	9.000	✓		"	
V	0.375	+/-0.010	0.381	✓		"	

Measured by: SL	Audited by: B.A	Prototype Approval: N/A
Date: 11/01/03	Date: 11/01/05	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015 KJ/RF	<div style="display: inline-block; text-align: center;">   </div>